

Work Order ID 72838

Tuesday, August 16, 2011 9:16:28 AM



Page 1

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 8/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 11-08-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3282	Rev C								
100		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018 3- Deburr								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA579 & Dwg D3282 2-Deburr								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

(X9)

11/08/16

11-8-23

9 8

11-8-23

9 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

out 11/08/24

9

/

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

9x 0 M-f 11/08/25

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9

11-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 116551

SAD

11-08-26

9

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 11/08/29

8

180



Packaging

Packaging

Identify as per dwg & Stock Location: LG

0.00

Memo

0.00

X9

11/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Start Date: 8/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/29

11.08.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 16, 2011 9:16:34 AM

Page 1

Work Order ID: 72838

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B 05.09.23 Procedure change KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	----------------	--------------	---------------	----------------	--------

MS20470AD4-7		Purchased	No			100	Each	3,888.000	57	570			
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Rivet, Universal Head

Location	Loc Qty	Loc Code
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ST320	3888	
116081	282	
117423	958	
117887	1300	
118614	1348	

D2792-130		Manufactured	No			160	Each	9.0000	1	10			
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EXTRUSION

Location	Loc Qty	Loc Code
----------	---------	----------

HALL	9	
61630	9	

D3283-1		Manufactured	No			160	Each	73.0000	2	20			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--



Doubler

Location	Loc Qty	Loc Code
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ST045	59	
66947	29	
70765	30	
ST048	14	
66553	14	

SAD 11-08-26

570

10
9

BB 11/08/16

SAD 11-08-26

14

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

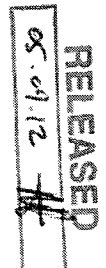
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.6	/	/	20.14	
1.500	+/-0.010	1.500	/	/	CNL-02	
3.000	+/-0.010	3.000	/	/		
6.000	+/-0.010	6.000	/	/		
1.250	+/-0.010	1.250	/	/		
30.000	+/-0.010	30.000	/	/		
1.500	+/-0.010	1.500	/	/		
72.01	+/-0.030	72.01	/	/		
61.75	+/-0.030	61.75	/	/		
57.50	+/-0.030	57.500	/	/		
49.19	+/-0.030	49.188	/	/		
43.94	+/-0.030	43.937	/	/		
39.69	+/-0.030	39.687	/	/		
26.68	+/-0.030	26.687	/	/		
0.55	+/-0.030	.550	/	/		
1.970	+/-0.010	1.974	/	/		
2.38	+/-0.030	2.278	/	/		
0.05	+/-0.030	.048	/	/	4	

Measured by: <i>DF</i>	Audited by: <i>CNL</i>	Prototype Approval:	N/A
Date: 11.8.23	Date: 11/08/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM <i>AK</i>	<i>Shel</i>

DATE

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D3282	SHEET 1 OF 2
DATE				TITLE	SCALE
05.08.09				FLOAT WEB, 206L/407	1:20
A		04.05.05		NEW ISSUE	
B		05.03.16		MOVE HOLES, ADD D3390-1 DOUBLERS	
C		05.08.09		REMOVE D3390-1, NOW MACHINED	



- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

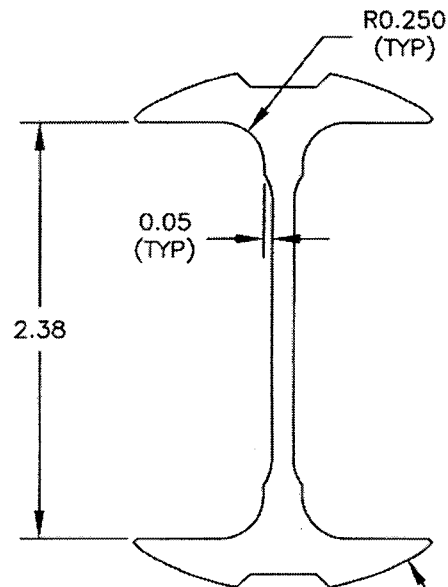
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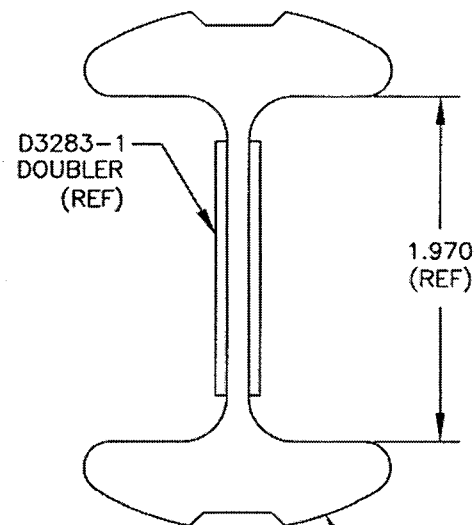


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
			20838	SHEET 2 OF 2
				SCALE
				1:20
				05.08.09
				RELEASED

SECTION A-A



SECTION B-B



D2792-130
EXTRUSION
(REF)

D2792-130
EXTRUSION
(REF)

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
 - 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
 - 3 UNIFORM SECTION B-B
 - 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
 - 5 DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
 - 6 UNIFORM SECTION A-A:
- 6 R1.00 BETWEEN SECTIONS

